

Date: Wednesday, 9/13/2006 4:30:02 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 28522  
 Estimate Number : 11539  
 P.O. Number : N/A Part Number : D30521  
 This Issue : 9/13/2006 S.O. No. : N/A Drawing Number : D3052 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : N/A Material : N/A  
 Due Date : 9/20/2006 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est:A 02.01.28 New Issue NG

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X04000 6061-T6 Bar 1.0" x 4.0"



S. 775



Comment: Qty.: 0.2625 f(s)/Unit Total : 5-2500 f(s)

6061-T6 Bar 1.0" x 4.0"

Material: 6061-T6 aluminum bar 4" X 1" thick

Batch: M 11991

x 11

En 06/09/16

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 5.600" long

En 06/09/16 x 11

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA184

Tumble & Deburr

En 06/09/17

x 20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/09/17

x 20

5.0 QC8 SECOND CHECK



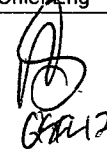


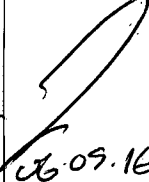
Comment: SECOND CHECK

MS 06/09/18

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: HD Date: 06/10/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/16	2	2 parts scrap. H995 <del>1995</del> Did not origin correctly on Restart	 GPH12	Scrap and Destroy	En 06/09/16	 06.09.16	 GPH12	 06.09.16

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:30:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 28522

Part Number: D30521

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-09-22

a.m 06-09-19

(21)

(19)

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06-09-19

a.m

06-09-22

(X)

(19)

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 120

PU 6/10/23 (1)  
LB 04/09/19

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

(20)

Job Completion



W 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

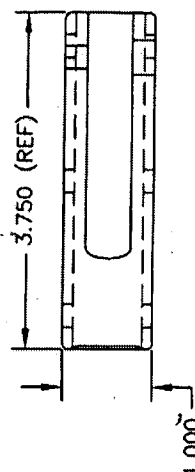
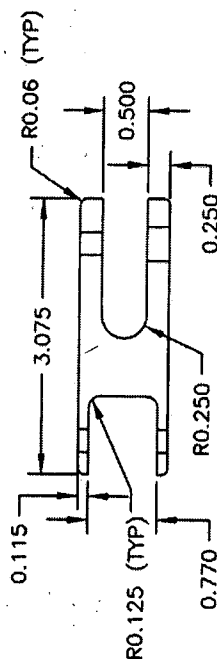
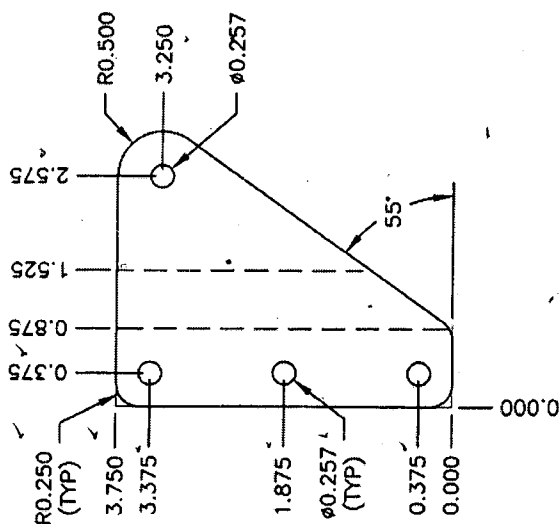
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

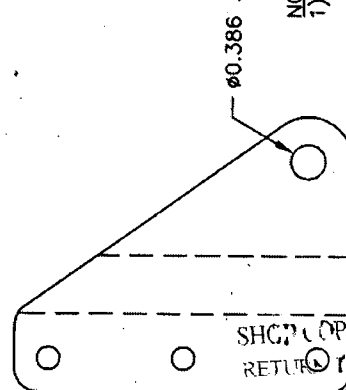
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3052	REV. A SHEET 1 OF 1
DATE 01.11.01		TITLE MOUNTING LUG	SCALE 1:2
A	01.11.01	NEW ISSUE	

**RELEASED**  
01.12.20 *[Signature]*

D3052-1 MOUNTING LUG

## NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) 1.00 THICK
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WITHOUT NOTICE  
WORK CENTER  
NO. 28522

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28522
<b>Description:</b> Mainly lug		<b>Part Number:</b> D3052-1
<b>Inspection Dwg:</b> D3052 , <b>Rev:</b> A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R. 0.250	$\pm 0.010$	0.250	✓		R-G	
0.375	"	0.375	✓		vern	
0.875	"	0.871	✓		"	
1.525	"	1.530	✓		"	
2.575	"	2.573	✓		"	
R. 0.500	"	0.500	✓		R-G	
3.250	"	3.255	✓		Height-Gauge	
Ø 0.257	$\begin{matrix} +0.005 \\ -0.001 \end{matrix}$	0.257	✓		vern	
Ø 0.375	$\pm 0.010$	0.366	✓		"	
Ø 1.875	$\pm 0.010$	1.869	✓		"	
3.375	"	3.371	✓		"	
3.750	"	3.758	✓		height-gauge	
0.115	$\pm 0.010$	0.114	✓		vern	
3.075	"	3.082	✓		Height-gauge	
R. 0.060	"	0.060	✓		R-G	
0.500	"	0.503	✓		vern	
0.250	"	0.250/0.241	✓		"	
0.770	"	0.765	✓		"	
1.000	$\pm 0.010$	1.004	✓		"	mnt. thickness
3.750	$\pm 0.010$	3.758	✓		Height-Gauge	
Ø 0.386	$\begin{matrix} +0.005 \\ -0.001 \end{matrix}$	0.389	✓		vern	

<b>Measured by:</b> En	<b>Audited by:</b> Jmd	<b>Prototype Approval:</b> K/1
<b>Date:</b> 06/09/16	<b>Date:</b> 06/09/17	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	